



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2500-3-114
Job Sheet 203581



5242468

Part No: D2500-3-114

Job Qty: 58 pcs

Part Name: Extension "I" Beam Web



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/19

Job Tracking No:

Due Date: 12/16/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG D2500 Rev.H IPP Rev. A 19.11.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	58 pcs	12/16/19	12/16/19	0.00	0.00	Purchasing - 1		DEC 19 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	58 pcs	12/16/19	12/16/19	0.00	0.00	Packaging 2 - 1 - B4B		DEC 19 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		

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						B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
120 QC 6	58 pcs	12/16/19	0.00	0.00		QC 6 - 9	
						QC 6 - 68	
						QC 6 - 61	
						QC 6 - 40	
						QC 6 - 81	DEC 19 2019
130 Packaging 3-1 - Stock - B4B	58 pcs	12/16/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Plex 11/21/19 4:23 PM Dart.Guerin.Kimberley	

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				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	TP
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	58 pcs	12/16/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-02
Part Op 100 - (Purchasing) Issue P/O: <u>45174</u> Hydro, die # MS-18867 Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material certification is attached 120 - (QC6- All purchased or subcontracted products) Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester 130 - Identify as per dwg & Stock Location: <u>HALL</u> LOCATION : LG002 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2500-3-114P	Extension "I" beam Web	58 Ea (1 ea)	100-Purchasing	<u>S242512</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Purchasing	D2500-3-114P	58	0	0	
Part Specifications					
Specifications could not be found.					

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LINE 1
D2500-3-114

SPECIFICATION CONTROL DRAWING

D2500-1-XXX EXTRUSION & D2500-3-XXX EXTRUSION



NOTES:
1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221
MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D2500-1 = 0.143 lb/in, D2500-3 = 0.086 lb/in
- 8) FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG). D2500-1 EXTRUSION MANUFACTURED FROM:
 - A) BON L DIE # 887105 -> PREFERRED
 - B) CARADON MIDEAST DIE # PAH-28030
 - C) CARADON MTL DIE # MH-18868
- 9) FOR D2500-3 PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG). D2500-3 EXTRUSION MANUFACTURED FROM:
 - A) CARADON INDALOX DIE # MS-18867

H	REDRAW & REFORMAT DWS, CORRECT BON L DIE #	CP	09.07.16
G	ADD DIE NUMBERS & DIMS IN INCHES (2N D2-1), TOLERANCES NOW PER CARADON DWS (SHIT 2)	PH	07.04.17
F	CHANGE MAT. TO 6061-T6	DS	97.08.29
E	CHANGE MATERIAL, TEMPER	DS	96.10.24
D	ADD MATERIAL PROPERTIES	DS	96.10.07
C	ADD D2500-3 WEB	BW	96.04.26
B	CHANGE INTERNAL WEB	DS	96.03.24
A	NEW ISSUE	DS	96.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.16		

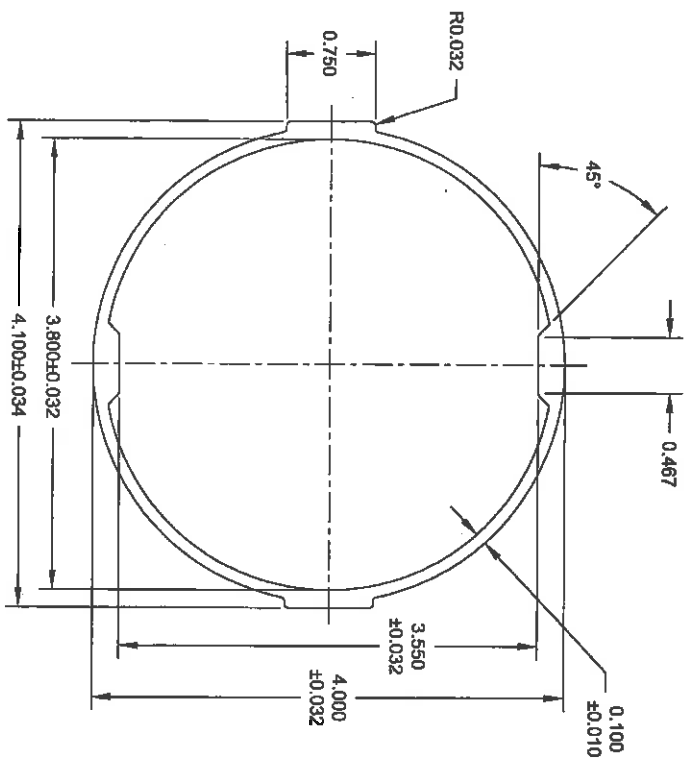
DART AEROSPACE LTD
HAWKESBURY, ONTARIO CANADA

DRAWING NO. D2500
REV. H
SHEET 1 OF 2
SCALE NTS

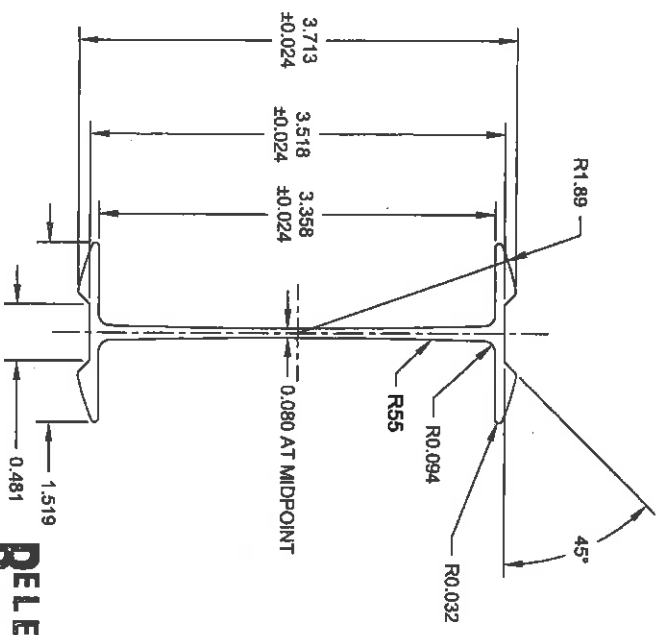
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RELEASED
2010-02-02
JMP

LINE 1
02500-3-114



D2500-1



D2500-3

DESIGN	4	DART AEROSPACE LTD
DRAWN	4	HAWKESBURY, ONTARIO, CANADA
CHECKED	4	
MFG. APPR.	4	
APPROVED	4	
DATE	09.07.16	
TITLE	EXTRUSION	
SCALE	NTS	

RELEASED
R 2010-02-02
JRP

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045174



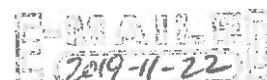
5242468

Supplier: SAP001-VC
Hydro
c/o M91634, P.O. Box 11634
Succursale Centre Ville
Montreal
QC
H3C 5Y9 Canada
Phone: 877-922-7272
Fax: 800 563 8310

PO No: POHB045174
PO Date: 11/21/19
Due Date: 12/13/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:



Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203581	D2500-3-114P	D2500 Rev H			Extension "I" beam Web as per drawing D2500 - length is 114"; die MS-18867	Firmed	-	12/13/19	74 Ea	0 Ea	74 Ea	\$30.2006/Ea	\$2,234.84

Line Item Note: **per piece pricing includes the set up fee (\$350) for order below MOQ

Grand Total: \$2,234.84

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Handwritten signature: Kguerin

Plex 11/25/19 10:37 AM Dart.Guerin.Kimberley



Hydro Extrusion Canada, Inc
325, rue Avro
Pointe-Claire Québec H9R 5W3
Téléphone: (514) 697-5120
Télécopieur: (514) 694-8310

Packing Slip / 0181356
Détail de Livraison

Order no / 9111303 1
Commande

Ship to/Expédié à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Sold to/Vendu à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Special Instr / Instr. Spéciales			
Cust No/No du Client 201355		Cust No/No PO du Client HB045174		PPD/PAYÉ X	Ord Dte/Dte Comm 19/11/22		Our Ord Dte/ Notre Dte la Comm 19/11/22		Hydro H.S.T #: R857314058		
PST/TPV * 6122-5207			Terms/Cond		Date Required/ Date Requête		Shipped/ Expedi 19/12/17		Shipped Via/ Expédiée Par DART 17 DEC		
Item No	Ordered Weight Pcs/ Commande Poids Pcs	Hydro Die no/ Matrice d'Sapa	Customer Description/ Description de Client	Alloy & Temper/ Alliage et Trempage	Length Longueur	Backorder Wgt Pcs Arrière Poids Pcs	This Shipment Btls Pcs Wght Com Expédiée Ballots Pcs Poids				
1	253 74		DUE=2019/12/13 ASAP D2500-3 MS 18867 D2500-3 6061 T6 2896MM BUNDLE= 1438213 1438214 1438215 We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures DAS 82 9-89 DEC 19 2019				3 122 418 KGS 122 Received				

Aluminum Extrusions - Anodizing - Fabrication - Painting
Profils D'Aluminum - Anodisation - Fabrication - Peinture

The above items were received in good order.
Les articles ci-dessus ont été reçus en bon ordre.

By/Par.....



BILL OF LADING

NAME OF CARRIER - VOITURIER SONOMA EXPRESS		POINT OF ORIGIN-POINT D'EXPÉDITION CANADA	SHIPPING DATE-EXPÉDIÉ LE 2019/12/17									
CONSIGNEE-DESTINATAIRE DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7 TEL: 613-632-3336		SHIPPER - EXPÉDITEUR HYDRO EXTRUSION CANADA, INC. 325 RUE AVRO POINTE CLAIRE, PQ. CANADA H9R5W3 TEL: (514) 697-5120	COMMERCIAL INVOICE #: 259469									
			SHIPMENT #: 0084373									
			FREIGHT CHARGES / FRAIS DE TRANSPORT Truckload Invoices: PREPAID < https://carriers.gocloudlogistics.com/ LTL Invoices: Hydro Extrusion % CT Logistics, Team 8 P.O. BOX 30382, Cleveland, OH 44130 Contact: Transportation@Hydro.com									
PIÈCES/PACKAGES NOMBRE DE COLIS	DESCRIPTION OF ARTICLES AND SPECIAL MARKS DESIGNATION ET MARQUES SPÉCIALES	WEIGHT(SUBJ TO CORR.) POIDS(SAUF CORRECTION)										
3 Bundles	CONSISTS OF: ALUMINUM EXTRUSIONS-VARIOUS LENGTHS <table><tr><td>TOTAL SOLID</td><td>418.00</td><td>KGS NET</td></tr><tr><td>TOTAL SHIPPED</td><td>418.00</td><td>KGS NET</td></tr><tr><td></td><td>430.54</td><td>KGS GROSS</td></tr></table>			TOTAL SOLID	418.00	KGS NET	TOTAL SHIPPED	418.00	KGS NET		430.54	KGS GROSS
TOTAL SOLID	418.00	KGS NET										
TOTAL SHIPPED	418.00	KGS NET										
	430.54	KGS GROSS										
PACKING SLIP NOS: 181356												
HYDRO REF: 9111303												
CUST. ORDER #: HB045174												
SHIPPER-EXPÉDITEUR Hydro Extrusion Canada, Inc.		AGENT-VOITURIER	DECLARED VALUE OF SHIPMENT VALEUR DÉCLAR 3,133.30									
PER/PAR		PER/PAR	CURRENCY: CAD									

OF066BOL

THIS BILL OF LADING-EXPRESS SHIPPING CONTRACT IS TO BE SIGNED BY THE SHIPPER AND CARRIER
(CE CONNAISSEMENT/CONTRAT D'EXPÉDITION-EXPRESS DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)

ORIGINAL COPY